

ID 70304

02, 2011 2:37:52 PM

Page 1

D3214-1

Accept

Setup Start

Stop

Re ID:

Item Name: Placard

Start Date: 6/8/2011 Start Qty: 10.00

Required Date: 6/17/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3214

Rev B

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blanks: 3.70" x 2.70" | Drill hole and fillet corner as per Dwg
D3214 | Deburr | Identify as D3214-1

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Chemical Conversion Coat per QS1005 4.1

HandFinish

Memo

0.00

Hand Finishing

14 Bl 11-69

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70304

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Item ID: D3214-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Placard

Start Date: 6/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

OVEN TEMPERATURE:

2:00
320°F FINISH TIME:

2:30

14.X Ø M-11/06/09

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

14 BL 11-6-9

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Engrave text as per Folio FA394 and Dwg D3214

211/07/05

14 X

FIRAS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 70304

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Item ID: D3214-1

Accept

Revision ID:

Item Name: Placard

Start Date: 6/8/2011 Start Qty: 10.00

Required Date: 6/17/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 11/07/05

14

180

Identify as per dwg & Stock Location 202

0.00



Packaging

Memo

0.00

Packaging

11/7/05 (14)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/05
MF
11-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 2:37:49 PM

Page 1

Work Order ID: 70304

Parent Item: D3214-1

Parent Item Name: Placard



Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A1104.04.15 New issue KJ/RF
IPP Rev:B Now 6061-T6 06-06-23 JLM!!

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		110	sf	257.0000	0.0743	0.782105			

6061-T6 .080 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	257	
116268	33.5	
117285	223.5	

118 700

1.0 f # 11/06/07

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN F#	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3214	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE PLACARD		SCALE 1:1
A	04.01.27	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED
06.06.20 [Signature]

**D3214-1****NOTES**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70304
Description: PLACARD	Part Number:	D3214-1
Inspection Dwg: 3214, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

x	Prototype
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[illegible]

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 11/06/07	Date: 11-7-07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	